January-31-13 9:56:17 AM

Page 1

Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D2939-2 Saddle RH In. 2 1/31/13 2/22/13	206 Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	Accept	*N900040 Cust Item ID: Customer:	1100)*	Setup Start Stop	*NS1* *NS2*
Approvals:	Process Plan	i: Mr2	Date: 3-01-3 Date:	Tooling: SPC (Y/N):	Date:		F	Run Start	*NR1*
Sequence ID/ Work Center II Draw Nbr	D	Operation Description sion Nbr		Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty	•	Reject Insp. Number Stamp
D2939 100 *100* HAAS I HAAS CNC vertical 110 *110* Mill Conv	Rev (HAAS CNC VERTICAI Memo Program pai number are inspect as p	rt number and batch number programmed correctly.2-Mer dwg D2939 & attached D visually inspect as per	achine Step No 1 of Folio rimension Sheet 3-Machin	and visually	<u> </u>	12	Ø	
120 *120* QC Quality Control		Machine Ke QC1- Inspect dimension Memo	ryway and inspect per attach	ŧ	Syl 13/02/04		12	Ø	

						•			DQA:	Date	·
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UPI		QA Closed:	Date	:
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	0.				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chief Eng	g Desci	ription	Date	Verification	QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											-
					F	AULT CAT	EGORY				
Landin	Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	'Crimped at on Strip in n Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Instru Main Mislab Misre Offset	ction Incomplete ctions Incomplete/ tenance peled ad	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Ī	Turning S	Sequence			Finish	Out o	f Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Hand Finishing

January-31-13 9:56:17 AM Item ID: D2939-2 Accept *N900040100* Setup Start Revision ID: Item Name: Saddle RH In. 206 Start Date: 1/31/13 **Start Oty: 12.00** *12* Cust Item ID: Required Date: 2/22/13 Req'd Oty: 12.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Number Stamp Code **Qty** Otv 130 QC8- Inspect parts - second check 0.00 13/02/06 *130* OC Memo 0.00 Quality Control 12 1/6 13-2-7 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* HandFinish 0.00 Memo

NCR: Y	es / No				WORK ORDER NON-	CONFORI	MANCE / UPI	DATE	QA Closed:	Date:	
Morle Ordo					DISPOSITION			AGAINST DE			
Work Orde	1.				Rework	7 🖡	Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap]	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Thern	moforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	0	· · · · · · · · · · · · · · · · · · ·			Work Order Update]	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		·
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data											
quip/Tooling									·		
perator	_										
/laterial	_	1									
ietup	_										
Other	_										
rocess											
Supplier	_										
Training											
Jnapproved		1	<u> </u>			AULT CATE	GORV		<u>. </u>	<u>. </u>	
Landir	ng Gear				General	AULI CAIL					
Landin	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks			·	Broken/Damaged	├ ─┤	tion Incomplete		Part Incorre	 	Weld
•	Crushed/	Crimped.	_		Burrs		tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs	•			Contamination	Mainte	enance		Part Moved		
}	Heat Trea	at			Countersink	Mislab	eled		Positioned \	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	'Surge	Other
İ	Ripples in	-			Drill Holes	Offset		_			
ļ	Torque V	Vaves in 8	Extrusio	n	Drawing	Out of	Calibration				
Ī	Turning S	Sequence	!		Finish	Out of	Sequence			-	

Outside Dimensions

DQA: _____ Date: ____

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

155

Quality Control

Memo

QC

Page 3 January-31-13 9:56:17 AM Item ID: D2939-2 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle RH In, 206 Start Date: 1/31/13 **Start Qty: 12.00** *12* Cust Item ID: Required Date: 2/22/13 Req'd Qty: 12.00 **Customer:** Reference: . - - - - . . Run Approvals: **Process Plan:** Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 145 0.00 *145* 12 0 0 SprayPaint 0.00 Memo Spray Painting PRIME B_117319 START: 6:00 FINISH: 7100 DELFLEET BLUE B 121722 DELFLEET CLEAR B 118093 START: 12:30 FINISH: 1:30 155 QC14- Inspect Spray Paint 0.00

0.00

NCR:	Yes	1	No
NCK:	res	/	INO

DQA:

Date:

NCR:	Yes	/ No				WORK ORDER NON-	CONF	ORN	//ANCE / UPI	DATE			
		•							•		QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
TTOTA OTO	٠					Rework	7 		Skid-tube	Crosstube		Water Jet	Engineering
Part I	۷o.					Scrap	┪ ┇		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		-				Use-as-is	∏ 		noforming	Finishing		e/Packaging	Other
NCR I	۷o.					Work Order Update]		Large Fab	Composite		Supplier	
		<u> </u>]	5 .		1	اادن	A	tian	Cian 0		
Root		0-4-	Char			ption of work order update	Init			tion rintion	Sign &	Verification	QC Inspector
Cause	ı —	Date	Step	Qty		or Non-conformance	Chief	Eng	Desci	ription	Date	vernication	QC IIISPECTOR
Doc/Data	<u> </u>	-											
Equip/Tooling Operator	\vdash	1	!										
Operator Material	\vdash	-											
Setup	\vdash	1											
Other	\vdash	1											
Process	-	1											
Supplier	一	1											İ
Training		1									1		
Unapproved	Г								,				
		<u> </u>				F	AULT (CATE	GORY				
Landi	ng	Gear				General							
		Bending				Bend	Gr	rain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to (o/s	BOM/Route	На	ardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	ln:	specti	on Incomplete		Part Incorre	ct	Weld
•	: 1	Crushed/	Crimped			Burrs	\vdash		ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	Шм	lainte	nance	<u> </u>	Part Moved		
	L	Heat Trea	at			Countersink	├ ──	islabe			Positioned \		
		Inspection	-	Tube		Cut Too Short	М	isread	i		Power Loss/	'Surge	Other
	L	Ripples in	Bend			Drill Holes	<u> </u>	ffset					
	L	Torque W	aves in E	Extrusio	n _	Drawing	—		Calibration				· · · · · · · · · · · · · · · · · · ·
	L	Turning S	equence		_	Finish	+─-		Sequence				
		Wave/Tw	ist in Tul	be		Folio		utside	Dirnensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-31-13 9:56:17 AM Item ID: D2939-2 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle RH In. 206 **Start Date:** 1/31/13 **Start Qty: 12.00** Cust Item ID: Required Date: 2/22/13 Req'd Qty: 12.00 Customer: Reference: Run Process Plan: Approvals: Date: Tooling: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 170 Identify as per dwg & Stock Location *170* Packaging Memo 0.00 Packaging 180 QC21- Final Inspection - Work Order Release 0.00 *120* MV 14 QC Memo 0.00 Quality Control

NCR:	/es	/ No				WORK ORDER NON-	CON	NFORM	ΛΑΝCE / UPI	DATE	DQA:	Date:	
iver.	CJ	, 110									QA Closed:	Date:	
Vork Orde	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part f	lo.					Rework Scrap Use-as-is Work Order Update	Scrap Use-as-is Useras-is Work Order Update Large Fab Composite Supplier Qual						
Root					Descri	ption of work order update	Ti	nitial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining			·						,				
							FAUL	T CATE	GORY				
Landi	ng (Gear Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning S	Crimped. It In Strip in Bend Vaves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw				Folio		Outside	Dirnensions				

Wave/Twist in Tube

Folio

Picklist Print

January-31-13 9:56:21 AM

Work Order ID: 96704

D2939-2

96704

Parent Item Name: Saddle RH In. 206

D2939-2

Start Date: 1/31/13

Required Date: 2/22/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

Parent Item:

IPP: B 00.06.26 New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	83.0000		12			
D6101-00)1								**		Po 1	3/01/	/31

Location	Loc Qty	Loc Code	
MAT040	33		
─ ♥ 91236	33		12
MAT042	50		
94445	50		

NCR≒ Ye	es /	No				WORK ORDER NON-0	CON	IFORN	//ANCE / UP	DATE	DQA: QA Closed:				
Nork Ordon						DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No	o					Scrap Machining Small Fab. Use-as-is Thermoforming Finishing				Crosstube Small Fab Finishing Composite	Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier				
Root					Descr	iption of work order update		nitial	Ac	tion	Sign &				
Cause	D	ate	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector		
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved								T CATE	GORY	·					
Landin	g Gear					General	7,00								
	Bending Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Cuffs Contamination Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Bom/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish					Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/ enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned Power Loss	ect lissing l	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other				
f		_	ist in Tul		<u> </u>	Folio		ł	Dimensions						

DART AEROSPACE LTD	Work Order:	96704
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			Х	First /	Article		Proto	type		,	
						F	Record	Actua	l Dim	ensions	
Dim	Min	Max		/No Go auge	1		2	3	,	4	5
А	0.100	0.140			.103	01	16	211	7	.119	-116
В	0.100	0.140			. 106	. 1	18	111	7	- 120	-116
С	0.100	0.140			. 113	.1	li .	. ile	>	- 112	.110
D	0.210	0.230			. 225	.2	25	. 22	26	, 274	- 224
. E	1.245	1.255			1,250		SO		30	1.250	1,250
F	1.245	1.255			1.250	1 2	SD	(2	50	1 250	1.250
G	2.495	2.505			2,500	2.	500		70	2.500	2.500
Н	0.510	0.515			4517		512		12	(512	1512
ı	1.572	1.582		-	1.577		577		77	1,577	1,577
J	2.495	2.505			2.50p	+	500	25	ÓΣ	2 500	7.500
K	0.257	0.262			258		58	-25	3	.258	725X
L	0.312	0.317			.314		314		14	.314	314
M	0.235	0.240			, 237		238		38	.238	• 238
N	0.100	0.140			122		22	. 12		• 121	170
0	0.540	0.560			.547		49	-55		350	,549
Р	0.490	0.510			.498		97		$\overline{\Sigma}$.sa	- 500
Q	3.715	3.725			3.720		720		720	3.720	3.720
R	2.720	2.760			2.740		740		740	2,740	7 740
S	0.240	0.270			151		154	.25		.253	253
T	0.100	0.180			.140		40		10	. 140	140
Ü	1.625	1.635			1.430		130		\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	1.630	1 630
V	1.362	1.372			1.362		367	11 77	2 7	1 367	1.367
W	0.316	0.321			.311.		3110	3	_	.316	316
X	1.250	1.270			1.263		62		3	1.263	1.262
Y	1.565	1.585			1,573		72	1, 29 1, 51		1.573	1.572
Z	0.178	0.198			100		88		8	188	(188
AA	3.173	0.700			'/30		43	,	20	188	, 100
AB											
AC											
AD						<u></u>					+
, (D			Ссер	t/Reject							
	Measured	d by: Om		16	~ ^ ~			D	ate:	13/02/00	4
	Audited	d by: 3, c	1						ate:		6
Proto	type Appro			N	/A 9-89			D	ate:		I/A
Rev	Date	Change								ised by	Approved
Α		New Issue							RF		pp. 0 + 0 u

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
С	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	77

DART AEROSPACE LTD	Work Order:	9670Y	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

X First Article Pr	ototype
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			<u> </u>			-71		
					Record	Actual Dim	ensions	
Dim	Min	Max	Go/No Go Gauge	XL	27	88	Aº 9	\$10
Α	0.100	0.140		*116	.115	0115	. 114	, 115
В	0.100	0.140		.116	, 115	. 115	- 115	-116
C	0.100	0.140		~ (O)8	-110	, 110	.108	, 109
D	0.210	0.230		·220	,220	. 219	.170	-221
E	1.245	1.255		1.250	1,250	1,250	1,250	1.280
F	1.245	1.255		1,250	1.250	1.250	1,250	1 250
G	2.495	2.505		2.500	2,500	2.500	2.500	2.500
Ξ	0.510	0.515		.512	.512	.512	.512	7.512
1	1.572	1.582		1577	1,577	1.577	1.577	1,577
J	2.495	2.505		2.500	2.500	2.500	2.500	7,500
K	0.257	0.262		.258	.258	,258	.258	-258
L	0.312	0.317		.314	-314	.314	.34	1314
М	0.235	0.240		,237	137	-237	. 236	.238
N	0.100	0.140		- 118	-117	a117	.117	.119
0	0.540	0.560		, SSO	.550	. 550	,549	.550
Р	0.490	0.510		.500	.502	.501 3,720	,499	.498
Q	3.715	3.725		3 720	3,720	3,720	3720	3,720
R	2.720	2.760		2.740	2.740	2.740	2' 740	2.740
S	0.240	0.270		-253	. 252	,253	:251	1251
T	0.100	0.180		.140	. 140	+ 140	140	.140
U	1.625	1.635		1.630	1.630	1.630	1 630	1,630
V	1.362	1.372		1367	(367	1367	1.367	1.367
W	0.316	0.321		.316	. 316	-316	316	-316
X	1.250	1.270		1.260	1.260	1.259	1,261	1,261
Υ	1.565	1.585		1.570	1.570	1,569	1.571	1.571
Ζ	0.178	0.198		. 122	.188	881.	188	.138
AA								•
AB								
AC								,
AD								
			Accept/Reject					
					····			

 Measured by:
 ♥
 Date:
 13/02/05

 Audited by:
 ★ Audited by:
 ★ Audited by:
 Date:
 13/02/05

 Prototype Approval:
 N/A
 Date:
 N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
С	07.03.21	Revised per drawing revision C	KJ/JLM ,	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	77

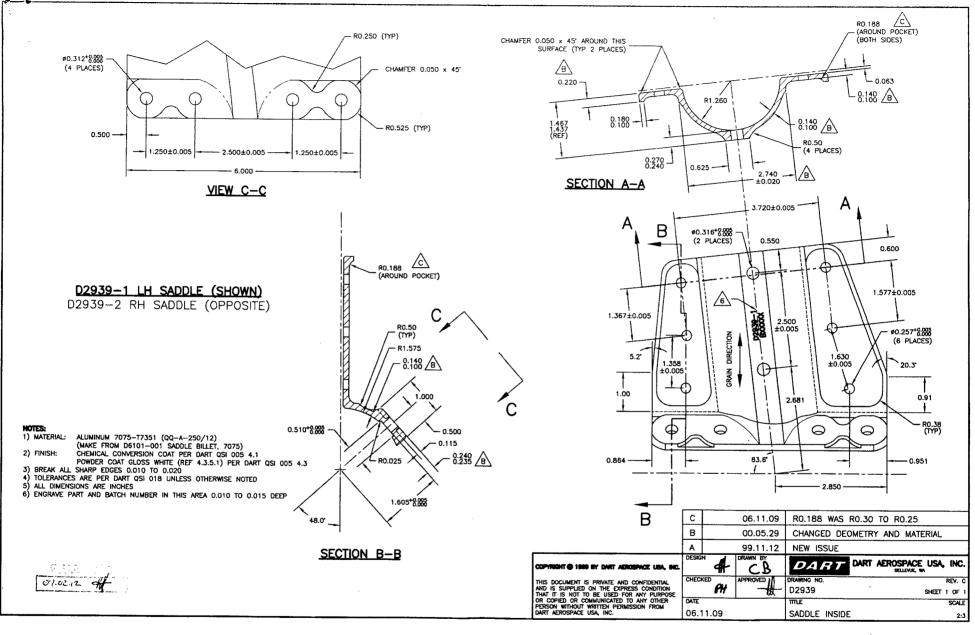
DART AEROSPACE LTD	Work Order:	96704
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First	Article	Protot	ype		
	Record Actual Dimensions							
Dim	Min	Max	Go/No Go Gauge	1/	12	3	4	5
Α	0.100	0.140		. 115	×116			
В	0.100	0.140		-116	.116			
С	0.100	0.140		.109	4110	·		
D	0.210	0.230		-219	1220			
E	1.245	1.255		1.250	1 250			1000
F	1.245	1.255		1.250	1.150			
G	2.495	2.505		2.500	1.500			
Н	0.510	0.515		,512	,512			
1	1.572	1.582		1,577	1.577			
J	2.495	2.505		2,500	2.500			
K	0.257	0.262		.258	·258			
L	0.312	0.317		-314	-314	,		
M	0.235	0.240		. 237	.737			
N	0.100	0.140		-117	. 117			
0	0.540	0.560		.549	. 549			
Р	0.490	0.510		.498	.494			
Q	3.715	3.725		3,710	3.720			
R	2.720	2.760		2.740	2 740			
S	0.240	0.270		-752	- 251			
Т	0.100	0.180		.140	.140			
U	1.625	1.635		1.630	1.630			
V	1.362	1.372		1.367	1.367	·		
W	0.316	0.321		.316	1.3iL			
Х	1.250	1.270		1260	1,260			
Υ	1.565	1.585		1.570	1.570			
Z	0.178	0.198		. 188	- 188			
AA								
AB								
AC								
AD								
			Accept/Reject					

Measured by: RD OAR			Date: 13/02/05
Audited by:		08	Date: 13/02/06
Prototype Approval:		N/A 89	Date: N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
С	07.03.21	Revised per drawing revision C	KJ/JLM , ,	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	\ <u>\</u>



SENTICOLY
REFERNICO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WESTER T NOTICE
WORK ORDER
13 01-31